

Work Order ID 86107

June-20-12 2:51:29 PM

86107

Page 1

Item ID: D3245-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 20/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3245

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3245 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

20 0 Jm 12-6-28

Durablacks

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20 0 Jm 12-6-28

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/7/04/79

60
720

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86107

June-20-12 2:51:29 PM

86107

Page 2

Item ID: D3245-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket

Stop

NS2

Start Date: 20/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 2329

0.00

130

Packaging

Memo

0.00

Packaging

20

12/06/29 JB

140

QC21- Final Inspection - Work Order Release

0.00


140

QC

Memo

0.00

Quality Control

12/7/3 

MC 12/06/29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-20-12 2:51:32 PM

Page 1

Work Order ID: 86107

86107

Parent Item: D3245-7

D3245-7

Parent Item Name: Gasket

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C04.11.17Made in-houseKJ/JLM
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3245		Manufactured	No			100	Each	21.0500	1	20			

D3245

Gasket

**

Jm 12-6-28

Location

Loc Qty

Loc Code

MAT052

21.05

77224

21.05

77224

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

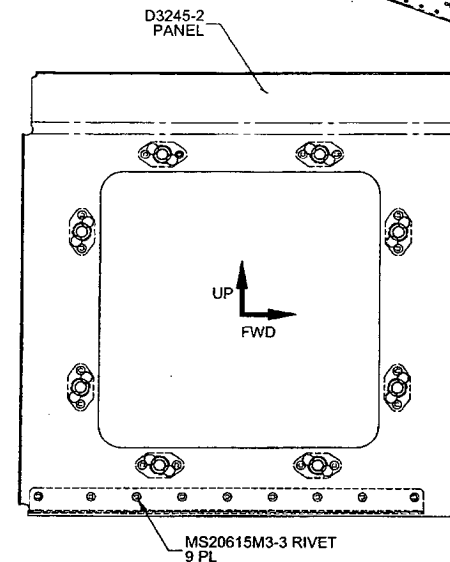
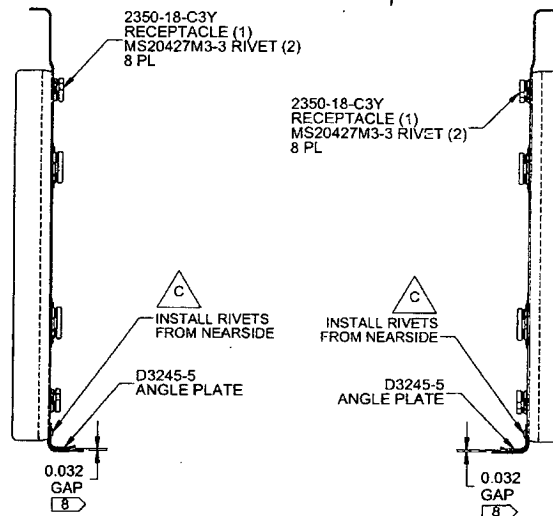
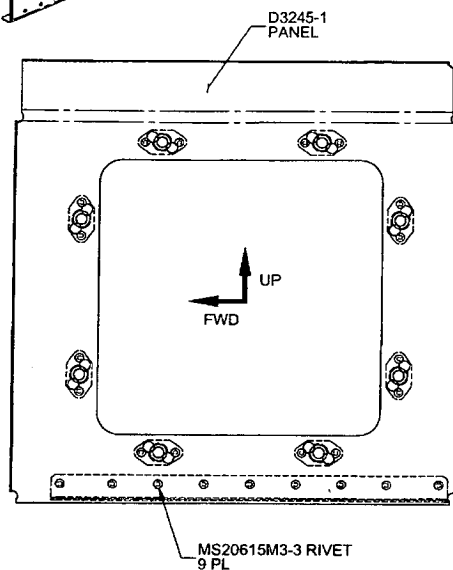
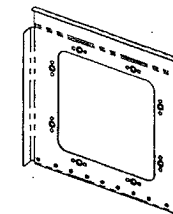
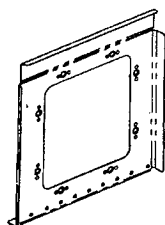
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 86107 MCT
12/06/20

D3245-041 ACCESS PANEL ASSY (LH)

D3245-042 ACCESS PANEL ASSY (RH)



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSY (LH)
	X	D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
1	1	D3245-2	PANEL
8	8	2350-18-C3Y	ANGLE PLATE
16	16	MS20427M3-3	RECEPTACLE
9	9	MS20615M3-3	RIVET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.83 lbs
- 8) TEMPORARILY INSERT A 0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL



C	ADDED NOTE 8, SHEET 1. SPECIFIED RIVET ORIENTATION (B4-1, B5-1). CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2). HOLE SIZE WAS 0.098, 9 PLACES (D6-6). HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-165		RP	12.04.11
	REMOVE Ø0.204 HOLES FROM D3245-1/1F. REMOVE MS21050-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN PINS TO GASKETS & REFORMAT DRAWING		MB	07.10.02
A	NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	MB			
CHECKED	A.P.	DRAWING NO. REV. C		
MFG. APPR.		D3245 SHEET 1 OF 7		
APPROVED		TITLE SCALE		
DE APPR.		ACCESS PANEL ASSY NTS		
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2012-05-07

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3245-3 DOOR

2351-20-012-C3Y STUD
127H-35 GROMMET
8 PL8.00
REF

8.00 REF

D3245-7 GASKET
REFINSTALL D3245-7
GASKET ON THIS SIDE
6**D3245-043 DOOR ASSY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

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CHECKED	AL	DRAWING NO.	REV. C
MFG. APPR.		D3245	SHEET 2 OF 7
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DE APPR.		ACCESS PANEL ASSY	NTS
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2012-05-07

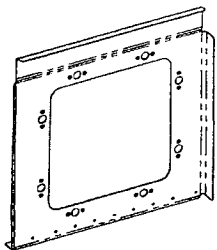
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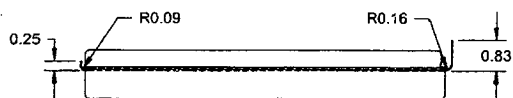
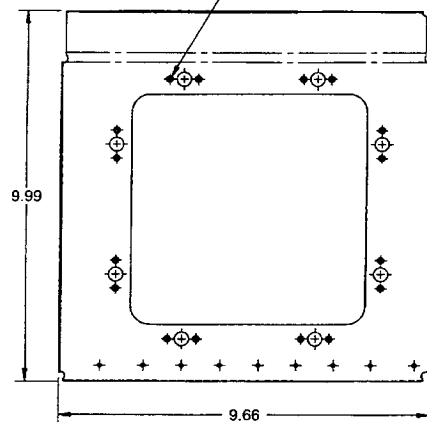
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

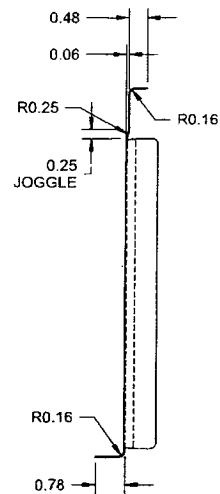
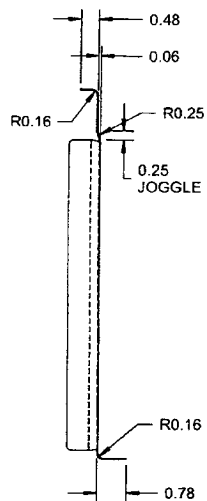
NOTE: Date & initial all entries



Ø 0.098 THRU
CSK Ø 0.170 X 100°
25 PL

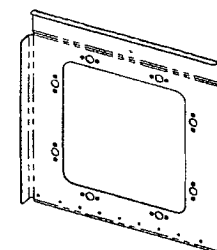
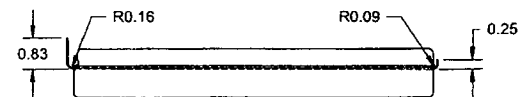
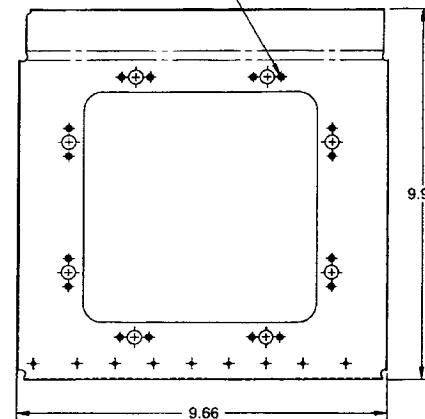


D3245-1 PANEL (LH)



D3245-2 PANEL (RH)

Ø 0.098 THRU
CSK Ø 0.170 X 100°
25 PL



NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AK	DRAWING NO.	REV. C
MFG. APPR.		D3245	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
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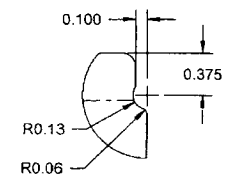
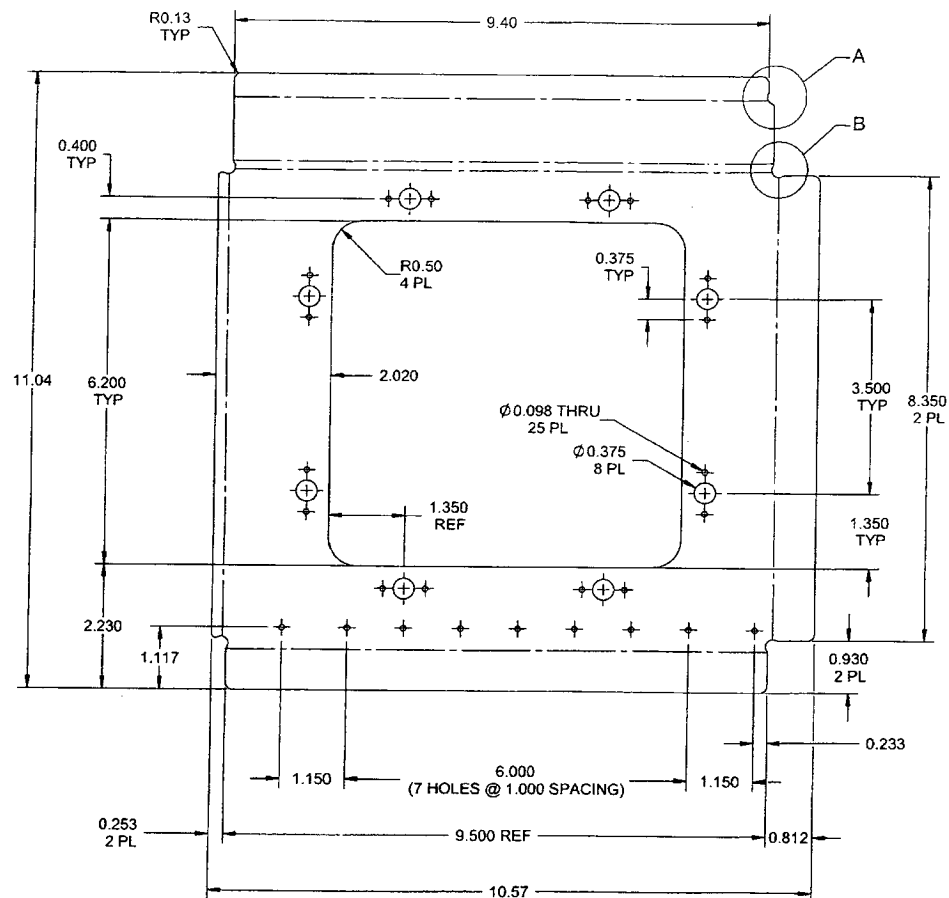
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

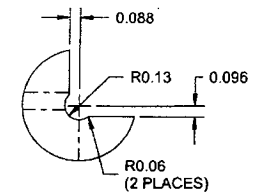
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
TYP. 4 PL
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

D3245-1F PANEL FLAT PATTERN

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO. D3245	REV. C
MFG. APPR.			SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS.
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2012-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

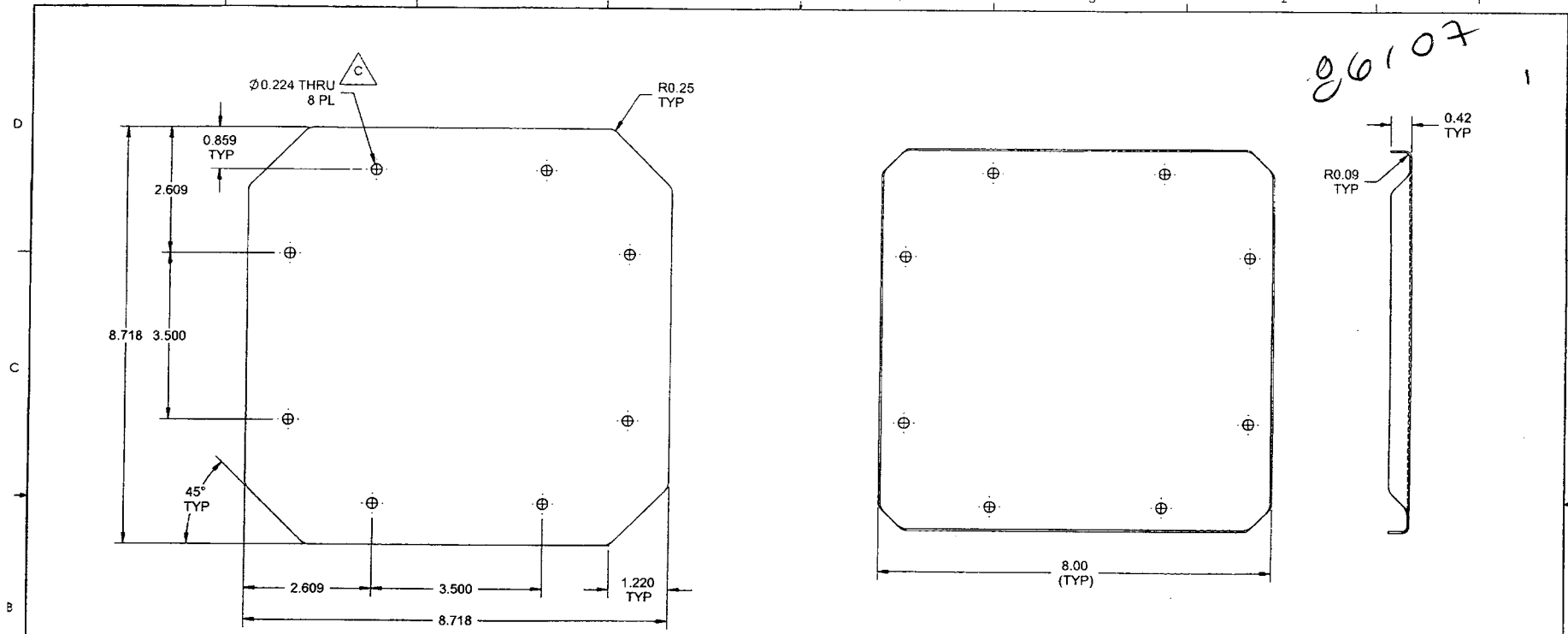
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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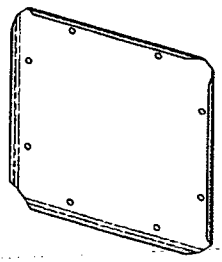


D3245-3F DOOR FLAT PATTERN

**D3245-3 DOOR
(MADE FROM D3245-3F)**

RELEASED
2012-05-07

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF: DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.66 lbs



DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
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MFG. APPR.		D3245	SHEET 5 OF 7
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

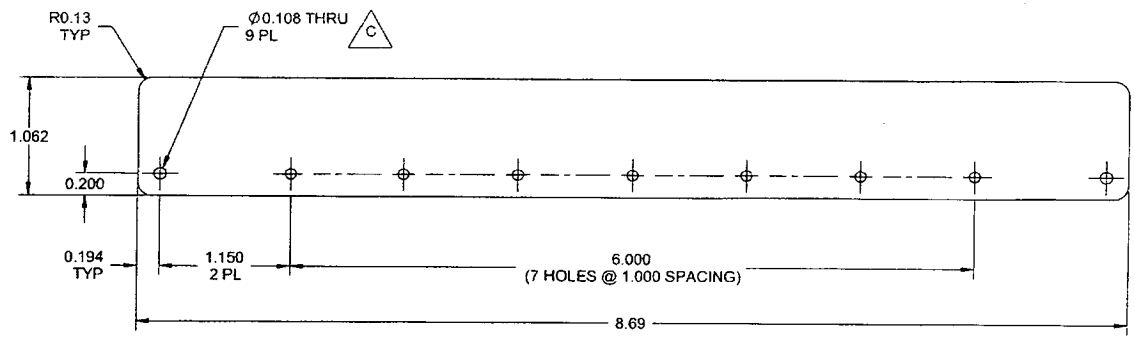
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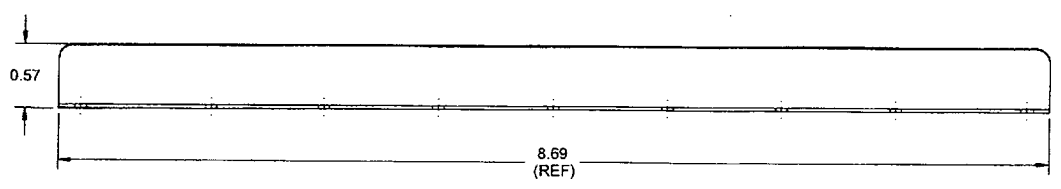
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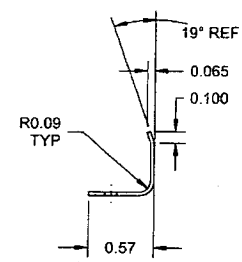
86107



D3245-5F FLAT PATTERN



D3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)



REL. 13 ED
R 2012-05-07

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AV	DRAWING NO.	REV. C
MFG. APPR.	ED	D3245	SHEET 6 OF 7
APPROVED	AND	TITLE	SCALE
DE APPR.	AND	ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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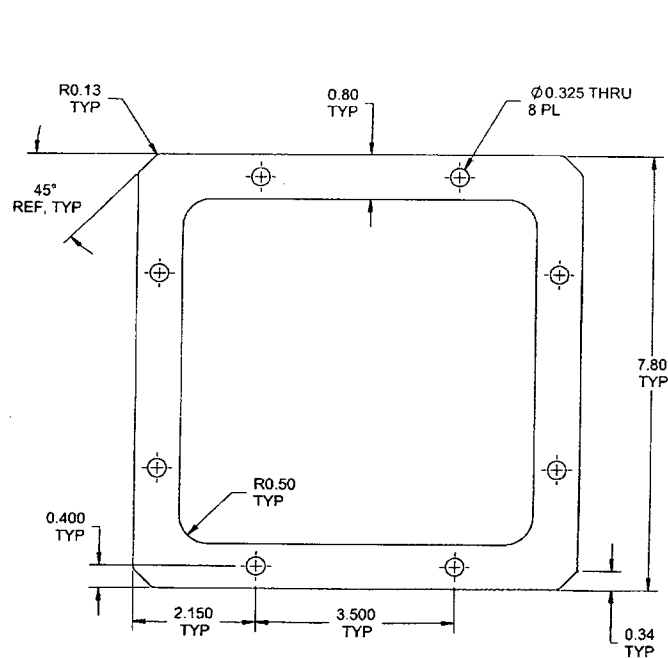
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

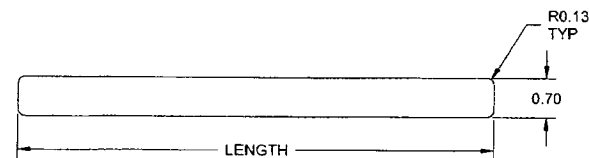
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86107



D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

REV. C
2012-05-07

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	MB	DRAWING NO. D3245	REV. C
MFG. APPR.	MB		SHEET 7 OF 7
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	ACCESS PANEL ASSY	NTS
DATE	12.04.11	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries